

Work Order ID 57888

Monday, April 19, 2010 3:35:21 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/4/20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750	Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

CL 10/5/3 1

8/10/05/03

57888

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

Skidtubes

Skidtubes

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ Aluminum Rod☐ M113207

8E 10/04/22

10-Grind welds flush as per Dwg D2750

DP 10-4-22

DP 10-4-21

M 10/4/22

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11- scribe batch #.

4/10/4/22

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/04/22

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/22

Memo

0.00

ⓧ

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

ⓧ

10-4-23

Memo

0.00

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Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 M 10/4/22

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Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ Sikaflex-291batch: ☐ ☐ ☐

exp. date: 10-8-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ ☐ Aluminum Rod

batch: M113207

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

DP 10-4-23

AWM 10-4-26

112429

BE 10/04/27

M10/4/27

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

BE 10/04/27

12-Deburr holes

11/04/27

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/06/07

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/06/07

(4)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

① BL 10-4-08

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30 AM

⇒ MU 10/04/28

①

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

① BL 10-4-29

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

D. BK 10-4-29

230



HandFinish

HandFinishing

0.00

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750SIKA FLEX 241
BATCH: M 112429

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1141895-Coat all exposed fasteners with "LPS Procyon"
batch: 104251

BK 10-4-29

D.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/04/30



Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

10-5-33

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/04/30



Quality Control

W/O:		WORK ORDER CHANGES					
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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
	LC 72								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

200 H

10-5-4

10/05/04

MF

10-5-4

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Picklist Print

Monday, April 19, 2010 3:35:21 PM

Page 1

Work Order ID: 57888

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/20/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225 Purchased No 220 Each 7,689.000 38.0000



Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

PK011

7689

110768 ✓

7689

AN3C5A Purchased No

230 Each

883.0000 34.0000



Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST350

500

114330 ✓

500

Main Warehouse

ST351

383

113121

53

114056 ✓

179

114108

51

114181

100

38. BK 10-4-29.

37 BK 10-4-29

~~27~~ 27 BK 10-4-29

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Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

679.0000 4.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

679

111982 ✓

679

230

Each

53.0000 4.0000

AN6C44A

Purchased

No



BOLT

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605

1

111649 ✓

50

4 BR 10-4-09

4 BR 10-4-09

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Shop Packet Print

Page 2

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Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased No 230 Each 19.0000 1.0000



BOLT



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

110847 ✓

19

19

AN960C10L

Purchased No 230 Each 0.0000 38.0000



washer

NAS 1149C 0332R.

114341



AN960C816L

Purchased No 230 Each 146.0000 1.0000



WASHER



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

110584

111424 ✓

146

100

46

1 BR 10-4-09.

38 BR 10-4-09.

1 BR 10-4-09

Dart Aerospace Ltd

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Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No 230 Each 150.0000 8.0000



Bushing



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST023 150

52311 ✓ 150

Manufactured No 230 Each 27.0000 1.0000

D3488-042



Blade Fitting Assembly, RH



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 7

52666 ✓ 7

Main Warehouse

FP008 20

53918 20

8 BR 10-4-29

1 BR 10-4-29

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Work Order ID: 57888

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3492-041

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

55446

42

Main Warehouse

FP031

40

57517 ✓

40

D3492-043

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

54682

42

Main Warehouse

FP013

40

57519 ✓

40

8 BR 10 4-29

8 BR 10 4-29

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3535-25

Manufactured No

230

Each

16.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

16

56065 ✓

4

56839 ✓

12

D3536-25

Manufactured No

230

Each

10.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

10

54479 ✓

10

1 BL 10-4-29.

1 BL 10-4-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 63.0000 3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 9

55465 9

Main Warehouse

FP17 54

57510 ✓ 54

3 Bk 10-4-29

D3631-1 Manufactured No 230 Each 302.0000 8.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST076 302

52693 ✓ 302

8 Bk 10-4-29

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

230

Each

1,589.000 4.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

1589

47628 ✓

89

51674

500

52505

1000

4. BR 10-4-29

D3791-1

Manufactured No

230

Each

18.0000 1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55457 ✓

7

Main Warehouse

FP17

11

56299

11

1 BR 10-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

14.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP18

14

51597 ✓

2

56300 ✓

12

D3793-3

Manufactured No

230

Each

10.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

10

55458 ✓

10

BR 10-4-09

BR 10-4-09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No 230 Each 19.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

55459 ✓

7

Main Warehouse

FP014

12

57537

12

1 BL 10-4-29

D3794-3 Manufactured No 230 Each 27.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

4

51907

4

Main Warehouse

FP18

23

56066 ✓

23

1 BL 10-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57888

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/20/2010

Start Qty: 1.00

Required Qty: 1.00

MS21043-6



NUT

Purchased No 230 Each 878.0000 4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST301

878

112314 ✓

878

MS21083C8



NUT

Purchased No 230 Each 50.0000 1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST303

50

113845 ✓

50

NAS1611-010



O-RING

Purchased No 230 Each 330.0000 8.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

330

110715

100

110915

230

H. 10-4-29

1 10-4-29

P10 →

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Dart Aerospace Ltd

W/O: 57888		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-11-09	230	CHANGE O'RINGS FOR D2594-S (55546)	BR	10-11-09	8.		S 10/15/03

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 57888

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 4/19/2010

Required Date: 4/20/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013



O-RING

Purchased No 230 Each 41.0000 8.0000



Warehouse
Location

Main Warehouse

FP

113743

41

41

250

Each

99.0000

2.0000



8 PR 10-4-29.
 10-5-3

AN8C21A



BOLT

Purchased No

Warehouse
Location

Main Warehouse

ST345

111605

113558

99

49

50

250

Each

146.0000

2.0000



2
 10-5-3

AN960C816L



WASHER

Purchased No

Warehouse
Location

Main Warehouse

ST348

110584

111424

146

100

46

2

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 57888

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/20/2010

Start Qty: 1.00

Required Qty: 1.00

D2741



Blade, 350 Skidtube

Manufactured No 250 Each 43.0000 1.0000



10-5-38

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST466

43

51931

11

55905

32

Manufactured No

250

Each

19.0000

2.0000



10-5-38

D3493-1



Washer

Manufactured No 250 Each 19.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST224

19

47710

19

Manufactured No

250

Each

51.0000

2.0000



10-5-38

D3532-1



Spacer

Manufactured No 250 Each 51.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST068

51

52321

51

10-5-38

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Monday, April 19, 2010 3:35:21 PM

Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3672-13

Purchased

No

250

Each

920.0000 2.0000



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

920

54363

920

MS21083C8

Purchased

No

250

Each

50.0000 2.0000



NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST303

50

113845

50

D2600-3-BENT

Manufactured

No

110

Each

3.0000 1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

3

55462

3

10-5-35

2
10-5-35

3535
057539 ① 4/10/22

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 19, 2010 3:35:21 PM

Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 40.0000 1.0000
 Cap

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	40	
47488	21	
51922	19	

1 11/04/22

D2739 Manufactured No 160 Each 7.0000 1.0000
 350 I Beam

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	7	
55986	1	
56060	6	

DP/AWT 10-4-26

D2743 Manufactured No 160 Each 130.0000 8.0000
 Crossbolt Spacer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	130	
50281	50	
52310	80	

8 DE 10/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57888



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/20/2010

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

40.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

40

55010

40

D3490-1

Manufactured No

160

Each

73.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

73

51932

8

57723

65

4 BE 10/04/27

4 BE 10/04/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

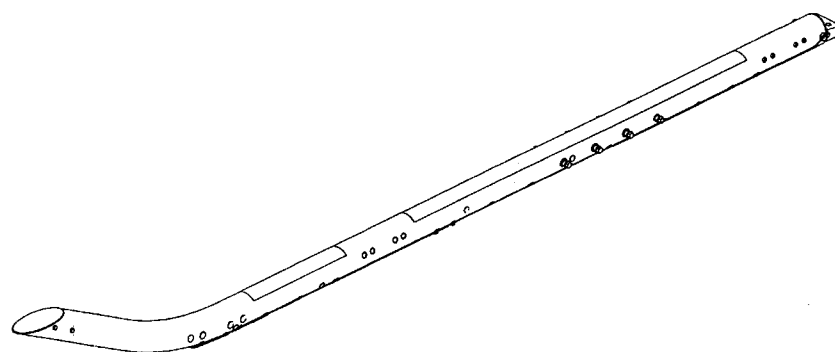
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

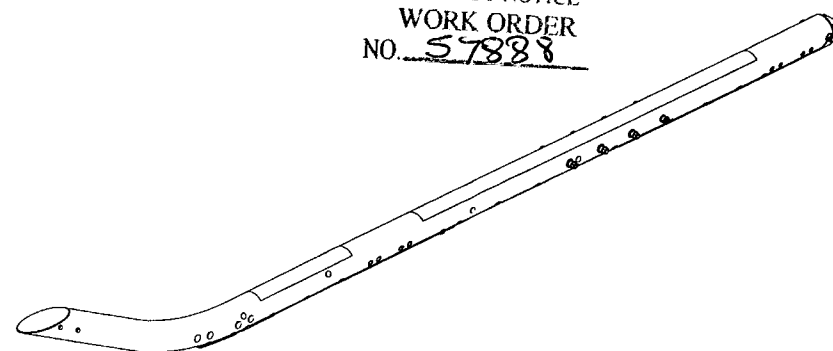
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AST SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RAH		
CHECKED			
MFG. APPR.	AS		
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



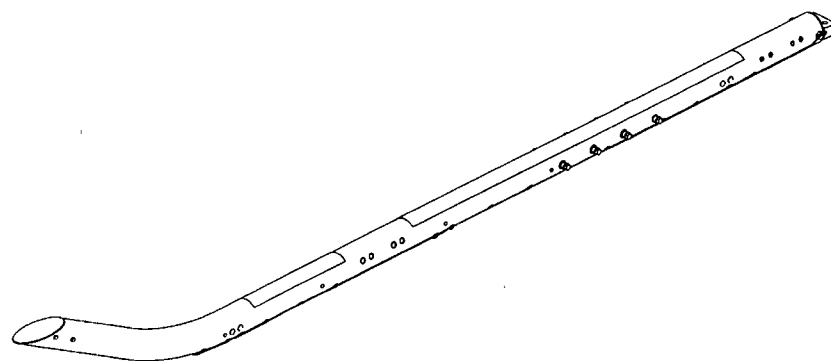
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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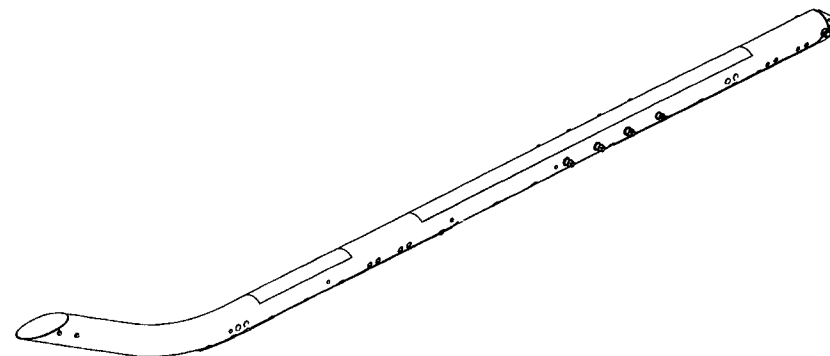
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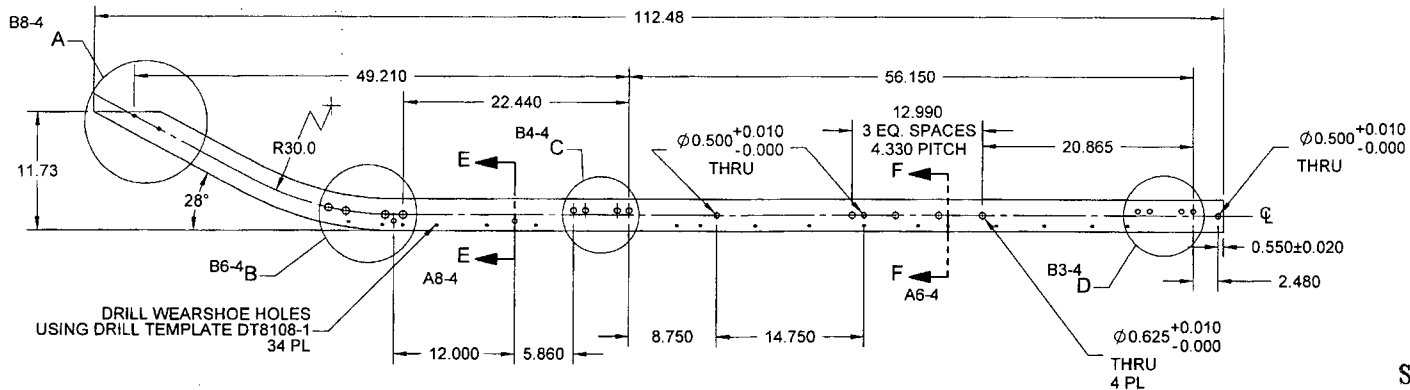
D2750-043 350 SKIDTUBE ASSEMBLY, LH



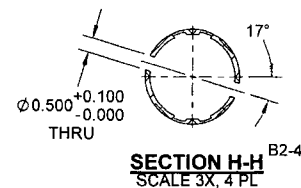
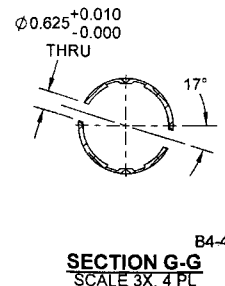
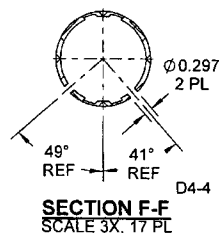
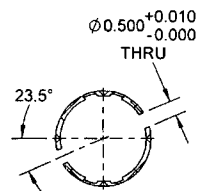
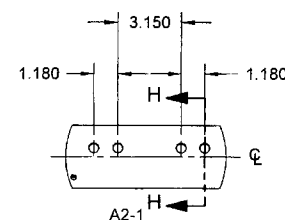
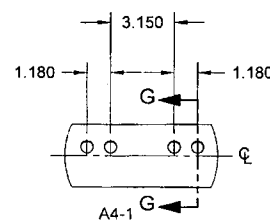
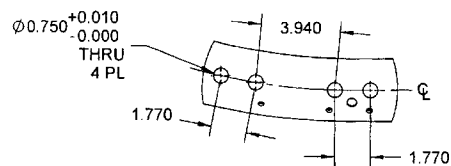
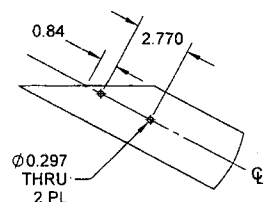
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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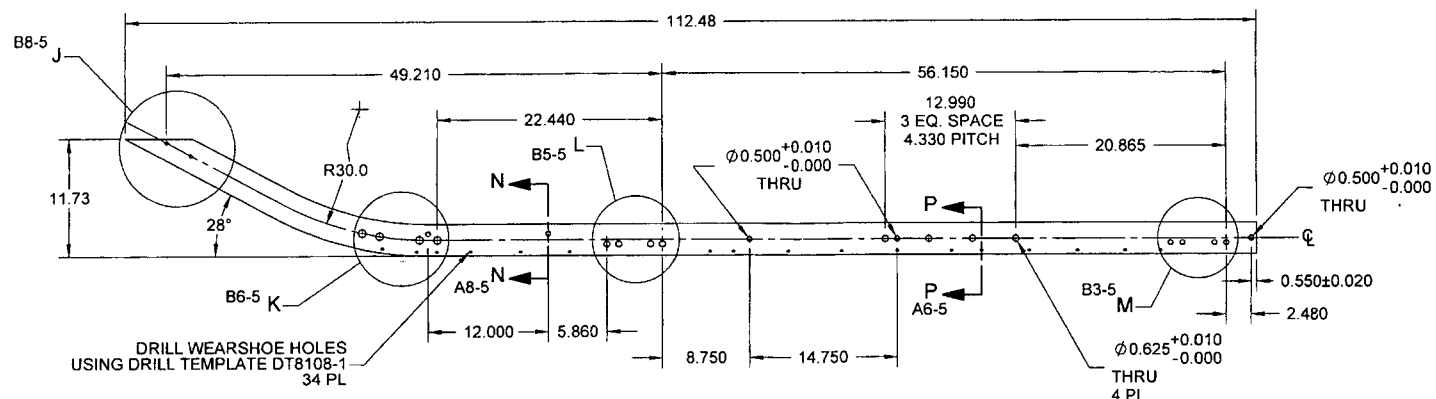
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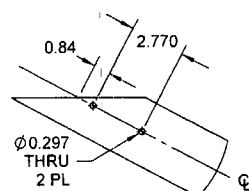
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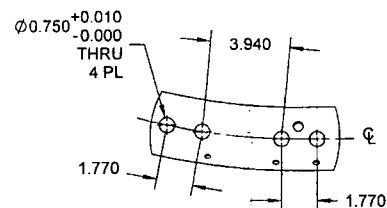
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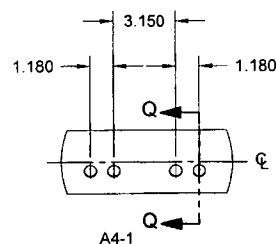
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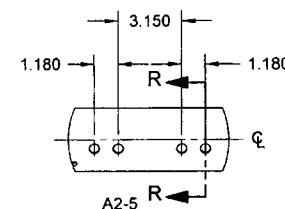
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SCALE 2X



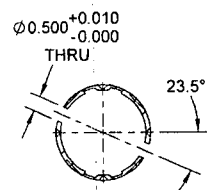
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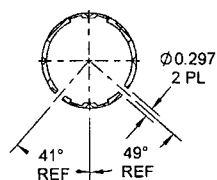
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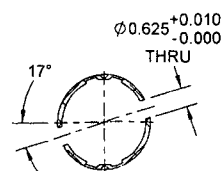
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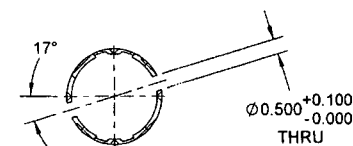
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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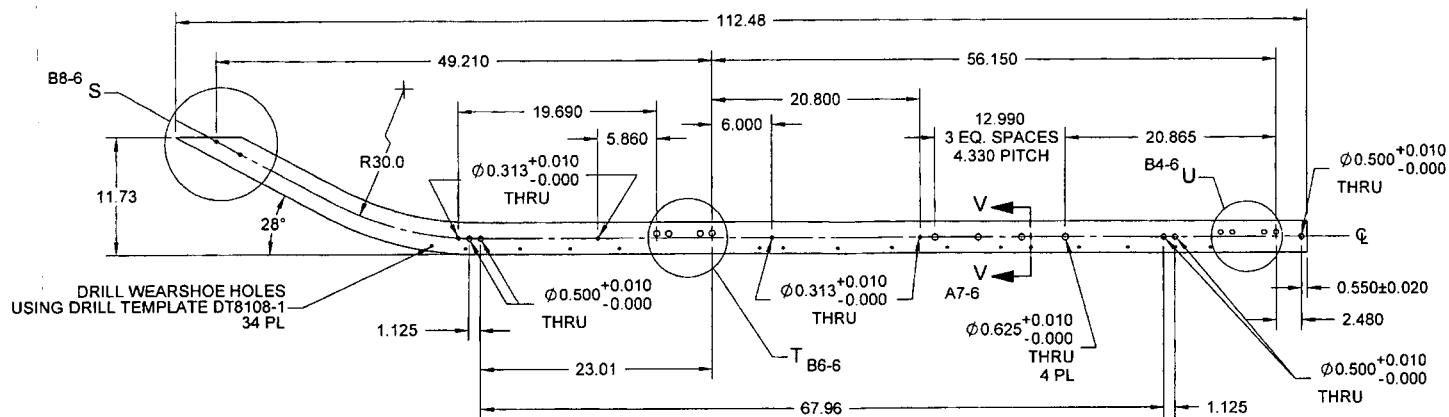
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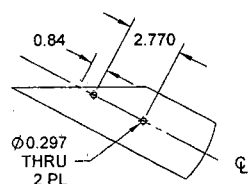
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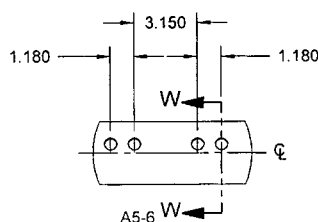
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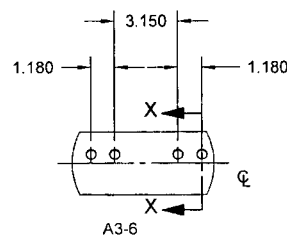
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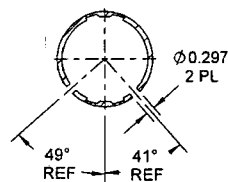
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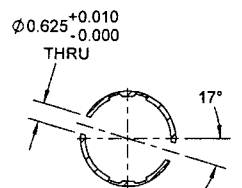
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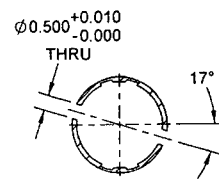
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL






SECTION W-W
SCALE 3X, 4 PL

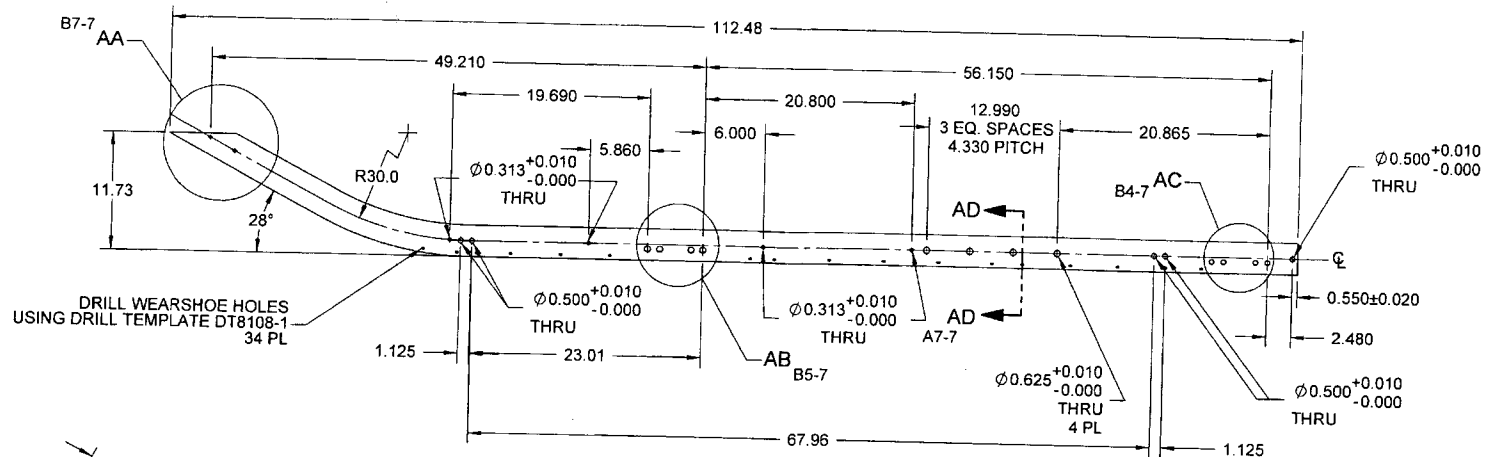


SECTION X-X
SCALE 3X, 4 PL

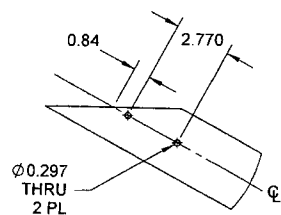
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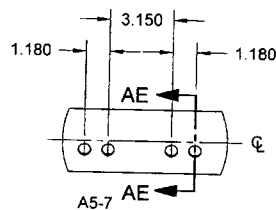
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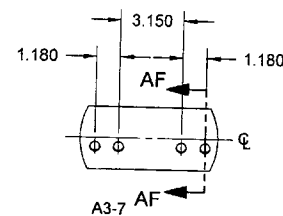
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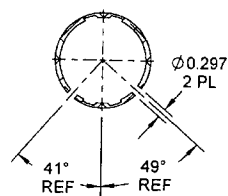
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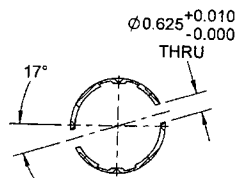
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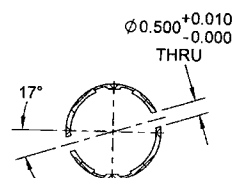
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



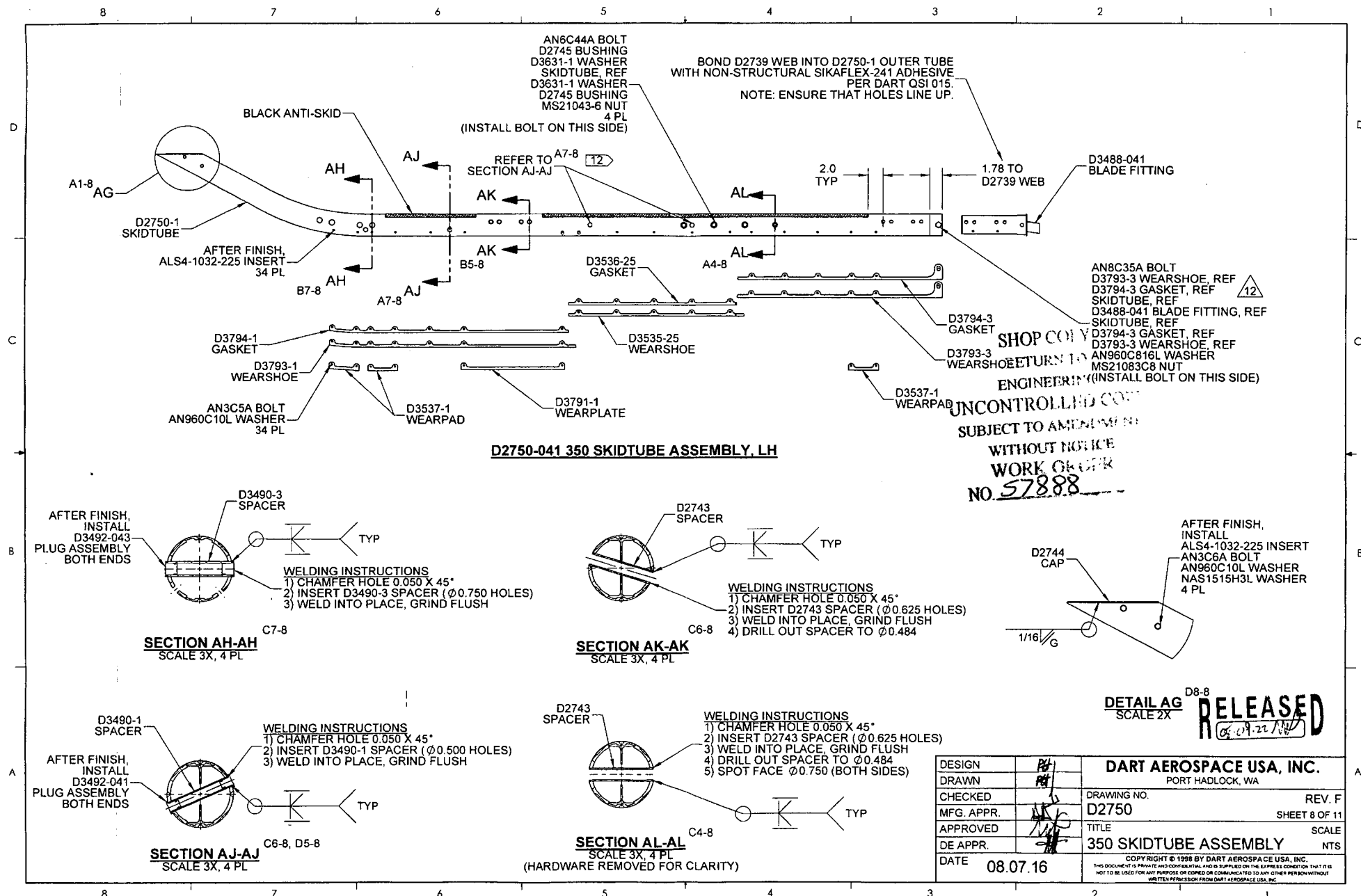
SECTION AF-AF
SCALE 3X, 4 PL

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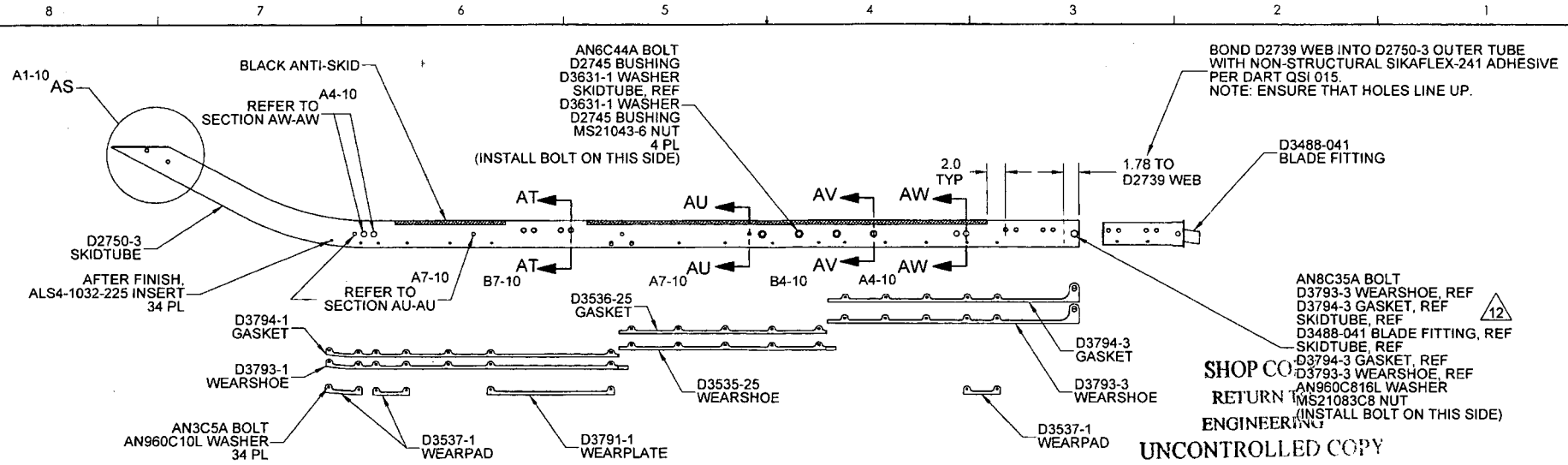
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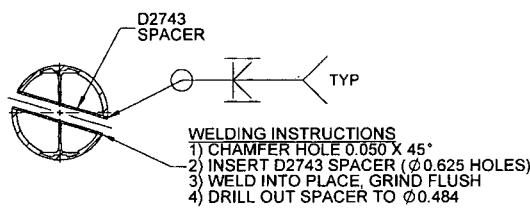


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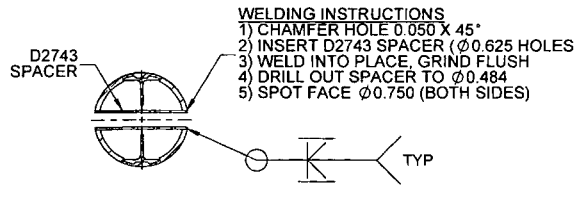


D2750-043 350 SKIDTUBE ASSEMBLY, LH

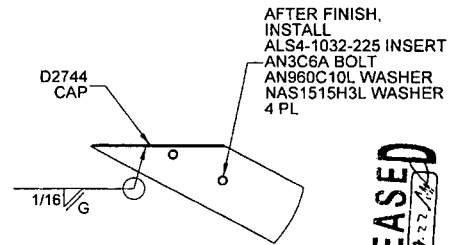
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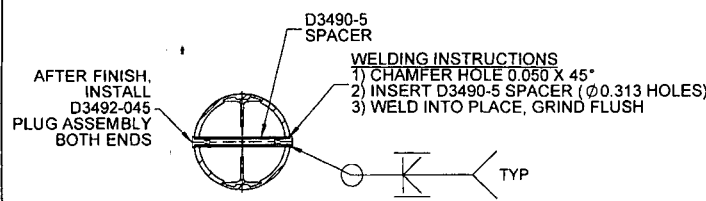
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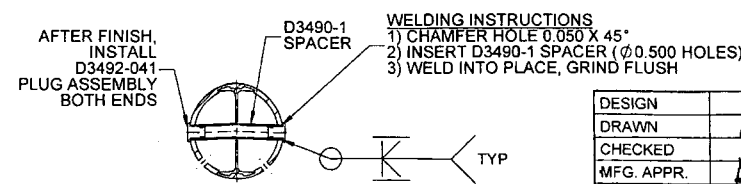
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



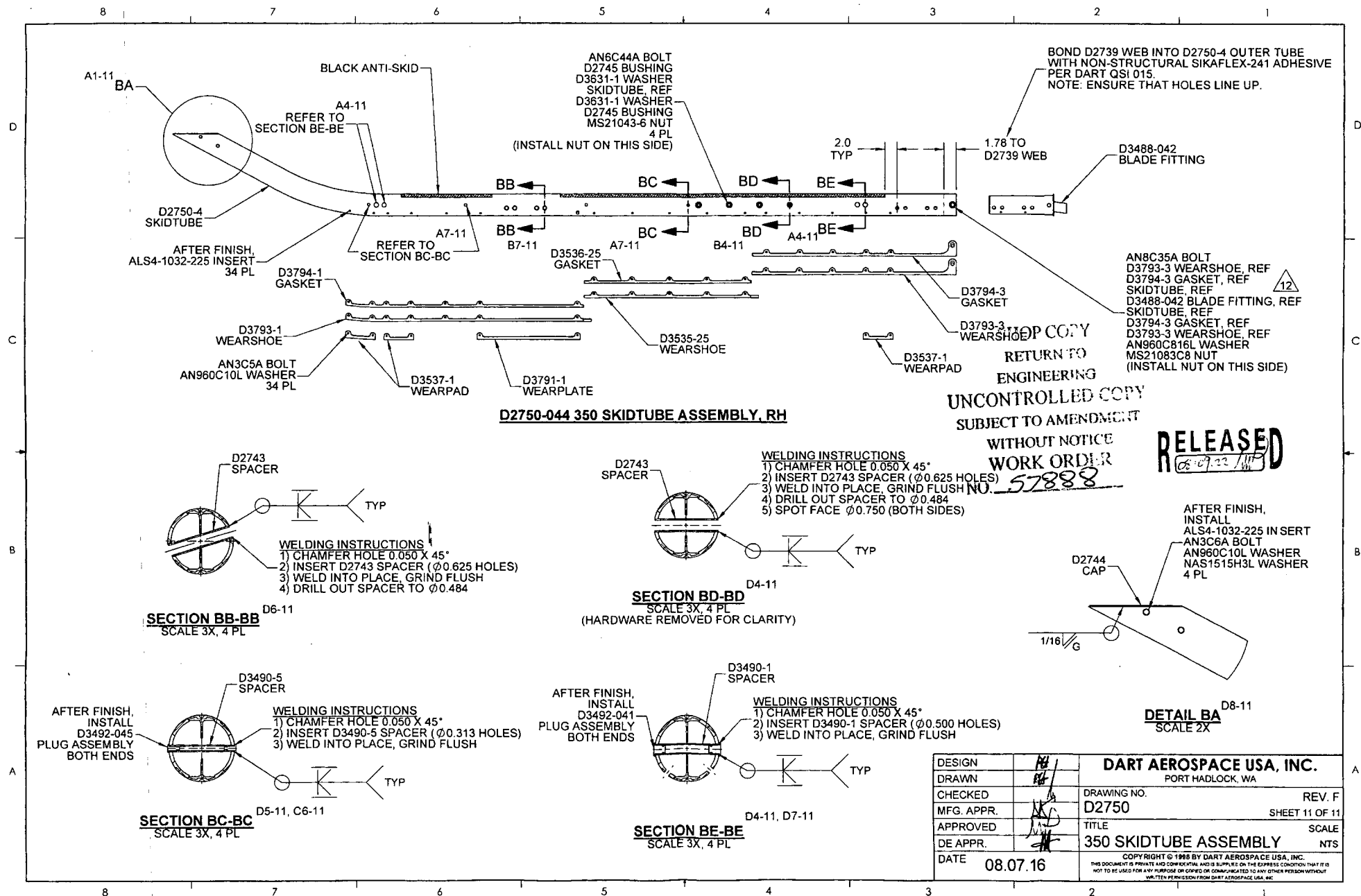
SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

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NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56276
Part number: D550-226 013
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. D. A. Date of Test Coupon 10.02.19

Welder Barclay Elliott Date of Test Coupon 10.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld